

Work Order ID 60224

Tuesday, June 29, 2010 11:38:51 AM



Page 1

Item ID: D206-547-043

Accept



Setup Start



Revision ID:

Item Name: Console High Slope

Stop



Start Date: 6/29/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/02/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D206-547	Rev F

100



Small Fab

0.00

Small Fab

Memo

0.00

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4□2-Deburr

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-547□2-Rivet extrusion to sides as per Dwg D206-547 usingRivet MS20470AD3-4

120



QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
Tool ID
Tool #
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

130



Large Fab

0.00

L 10-8-16 X-18

Large Fab

Memo

0.00

Large Fab

1-Tack weld as per Dwg D206-547 A/R

AL ROD

Batch: M11385

140



QC5- Inspect part completeness to step on W/O

0.00

S 10-8-16

QC

Memo

0.00

Quality Control

150



QC10- Inspect visual per QSI004- ground welds

0.00

C9 LH X5 RH

QC

Quality Control

0.00

S 10-8-16

C9 LH X5 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Small Fab

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Small Fab

Memo

0.00

Small Fab

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/08/16

180



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 11/25/88

Powdercoat

Memo

0.00

10/08/11

START TIME: 10:15 AM OVEN TEMPERATURE:
16:45 AM FINISH TIME: 320 °F

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

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Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC3- Inspect Part Finish

0.00

m 10 08 17 5

QC

Quality Control

200



Identify as per dwg & Stock Location:

0.00

MH 19/08/2010

Packaging

Packaging

210



QC21- Final Inspection - Work Order Release

0.00

10/08/2010

QC

Quality Control

0.00

*MF
10-8-2010*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 12:38:05 PM

Page 1

Work Order ID: 60224



Parent Item: D206-547-043



Parent Item Name: Console High Slope

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:I 06-01-05 Removed Packing Kit JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD3-4



Purchased

No

100

Each

11,008.00

20

100

E60/08/09

Rivet, Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST319

11008

111477

8332

15541

2676

100

D2024



Manufactured

No

110

sf

1,157.800

3.42

18

E60/08/09

Console Extrusion

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

MAT06

1157.8

1

1157.8

18

D2602-1



Manufactured

No

110

Each

4.0000

1

5

E60/08/09

Console Side, 206 Console

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST178

4

58206

4

4

B60300 (K)

D2602-2



Manufactured

No

110

Each

6.0000

1

5

E60/08/09

Console Side, 206 Console

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST177

2

52697

2

ST178

4

58207

4

4

B60301 (K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, June 29, 2010 12:38:05 PM

Page 2

Work Order ID: 60224



Parent Item: D206-547-043



Parent Item Name: Console High Slope

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 5.00

Required Qty: 5.00

D2606



Console Bracket, 206/407 Console

Manufactured No

110 Each 21.0000



5
J3/0/08/16



5

D2607



Bracket, 206 Console

Manufactured No

110 Each 17.0000



5
J3/0/08/16



4

1

MS20470AD3-3



Rivet,Universal Head

Purchased No

110 Each 8,491.000



40
J3/0/08/16



40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



ISSUED
APR 2001

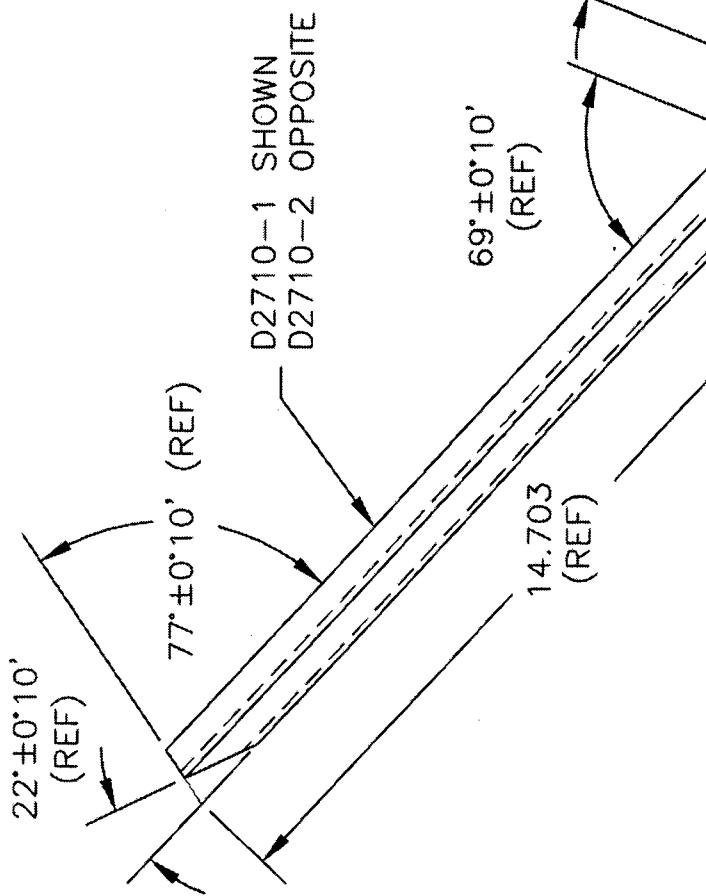
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60224

PJ.W-29

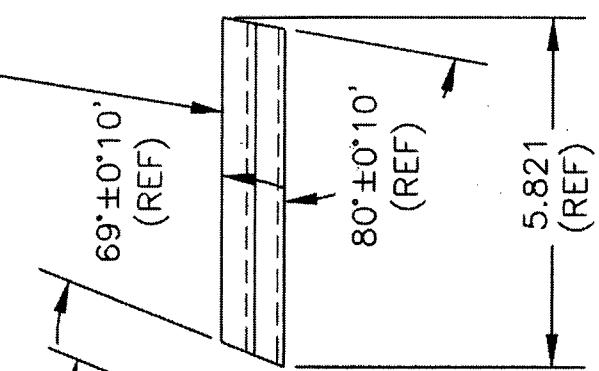
DESIGN <i>BW</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2710
DATE 99.02.11	TITLE CONSOLE SIDE RAIL	SCALE 1:3
A	97.10.25	NEW ISSUE
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)

RELEASED
99.03.05 KE

D2710-3 SHOWN
D2710-4 OPPOSITE



Copyright 1997 by DART AEROSPACE LTD



MATERIAL: MAKE FROM D2024 EXTRUSION
MAKE PER TEMPLATE # DT8264
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

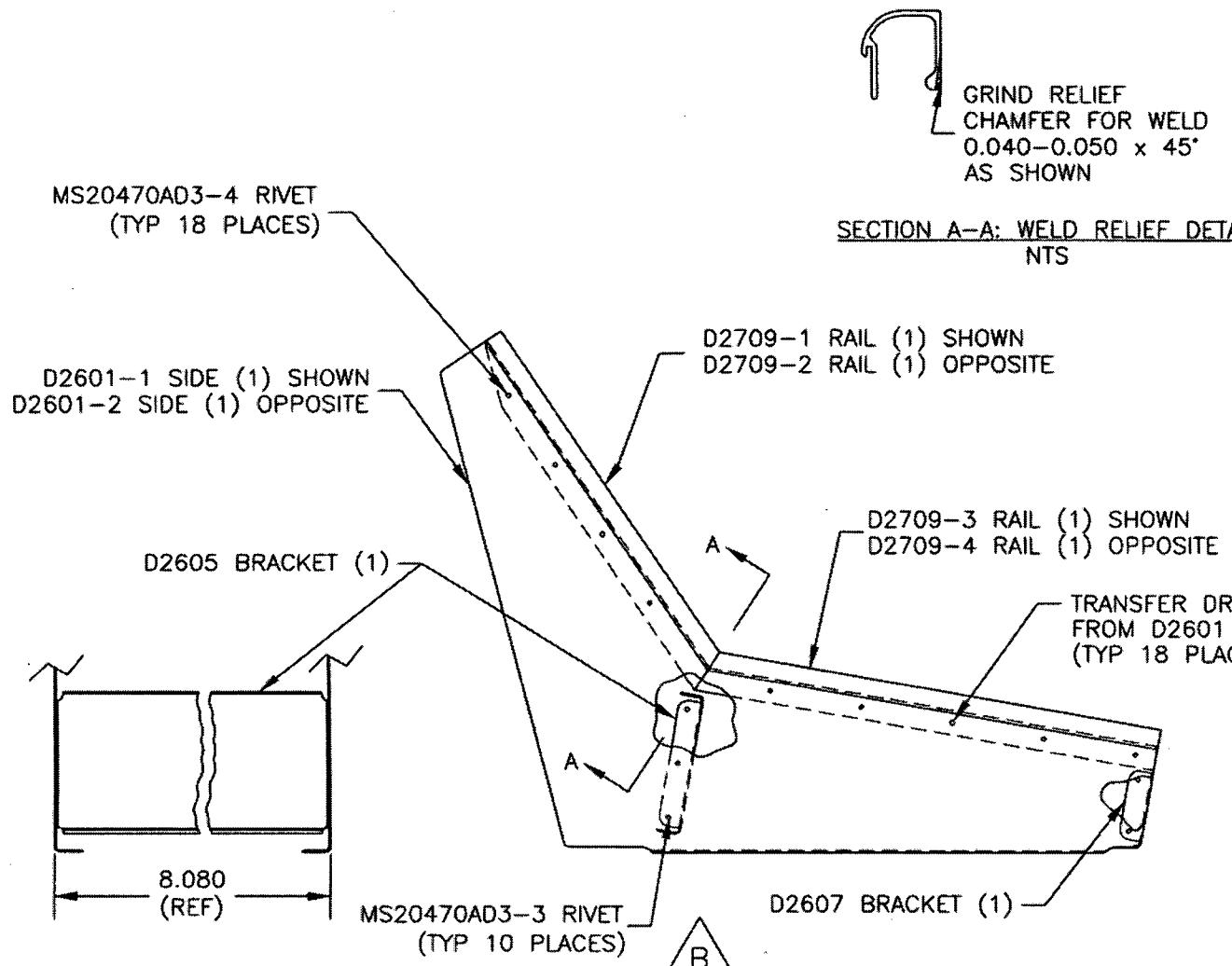
NOTE: Date & initial all entries

DART

DESIGN <i>BW</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE
REFERENCE ONLY

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
1				D2602-1	CONSOLE SIDE
1				D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
		1	1	D2710-1	CONSOLE SIDE RAIL
		1	1	D2710-2	CONSOLE SIDE RAIL
		1	1	D2710-3	CONSOLE SIDE RAIL
		1	1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET



D206-547-041 (206 LOW SLOPE CONSOLE)

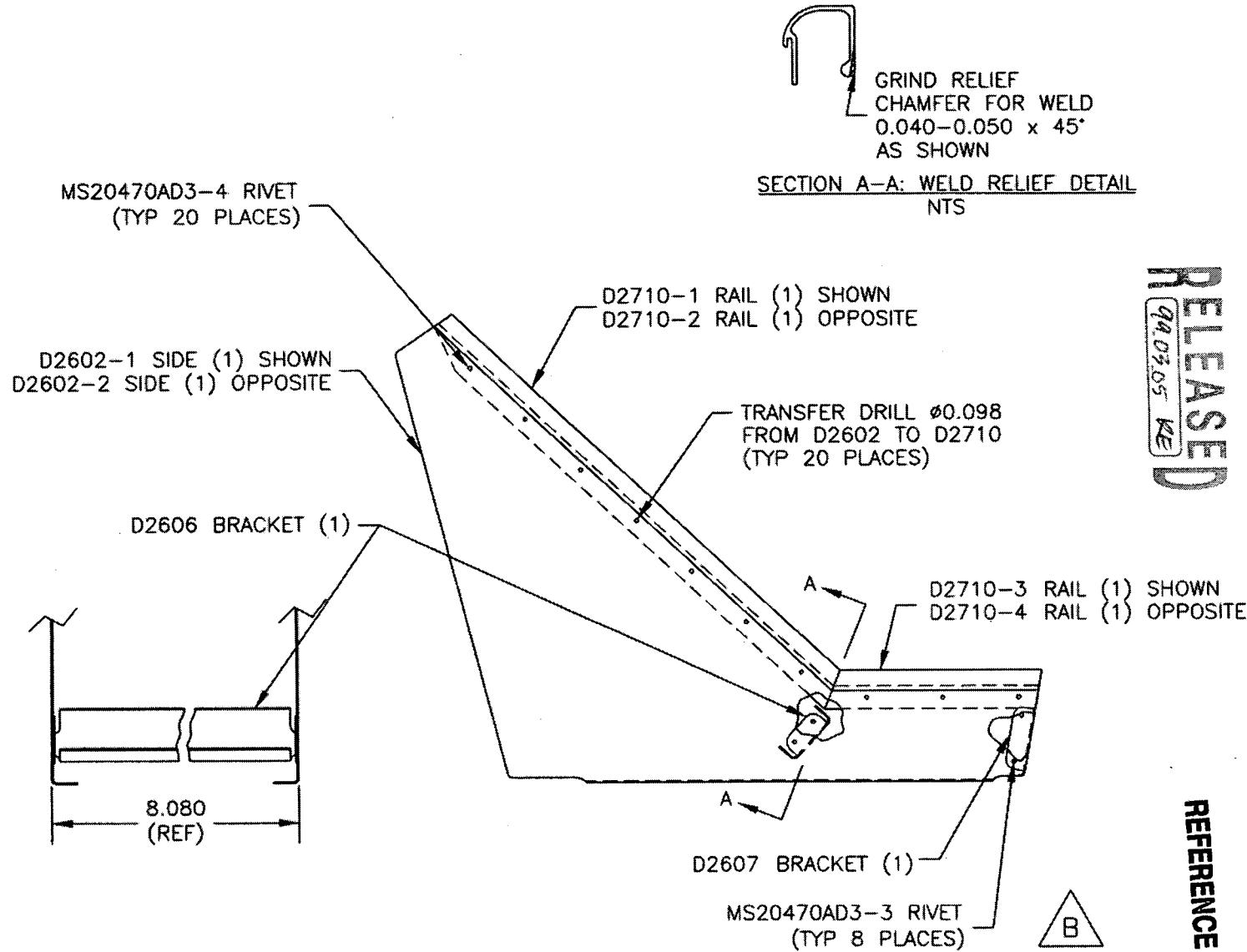
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.02.05
KE

DART

DESIGN B/W	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 2 OF 5 SCALE 1:4

REFERENCE ONLY



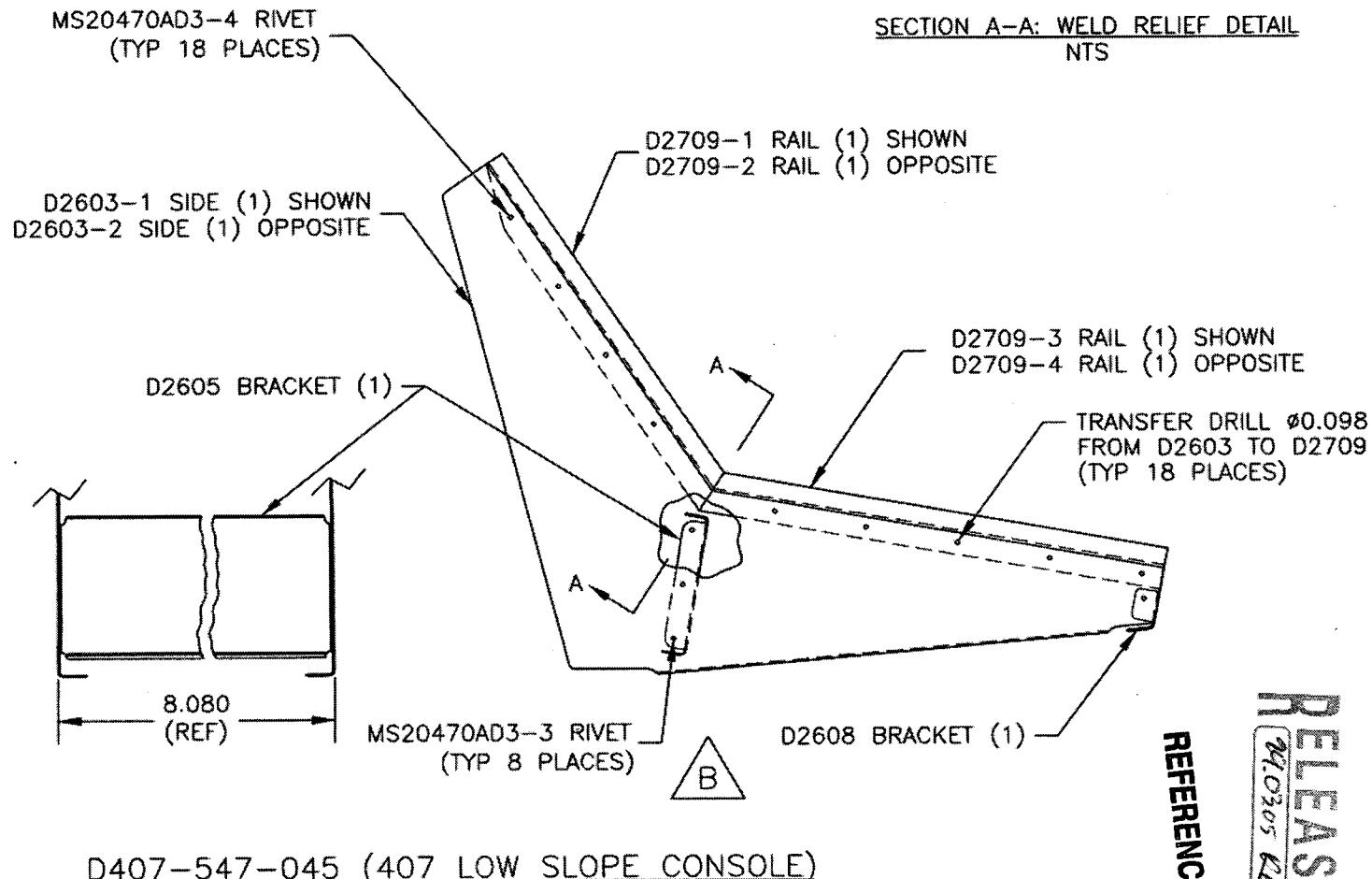
D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN <i>BW</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JP</i>	APPROVED <i>KE</i>	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 3 OF 5 SCALE 1:4

REFERENCE ONLY



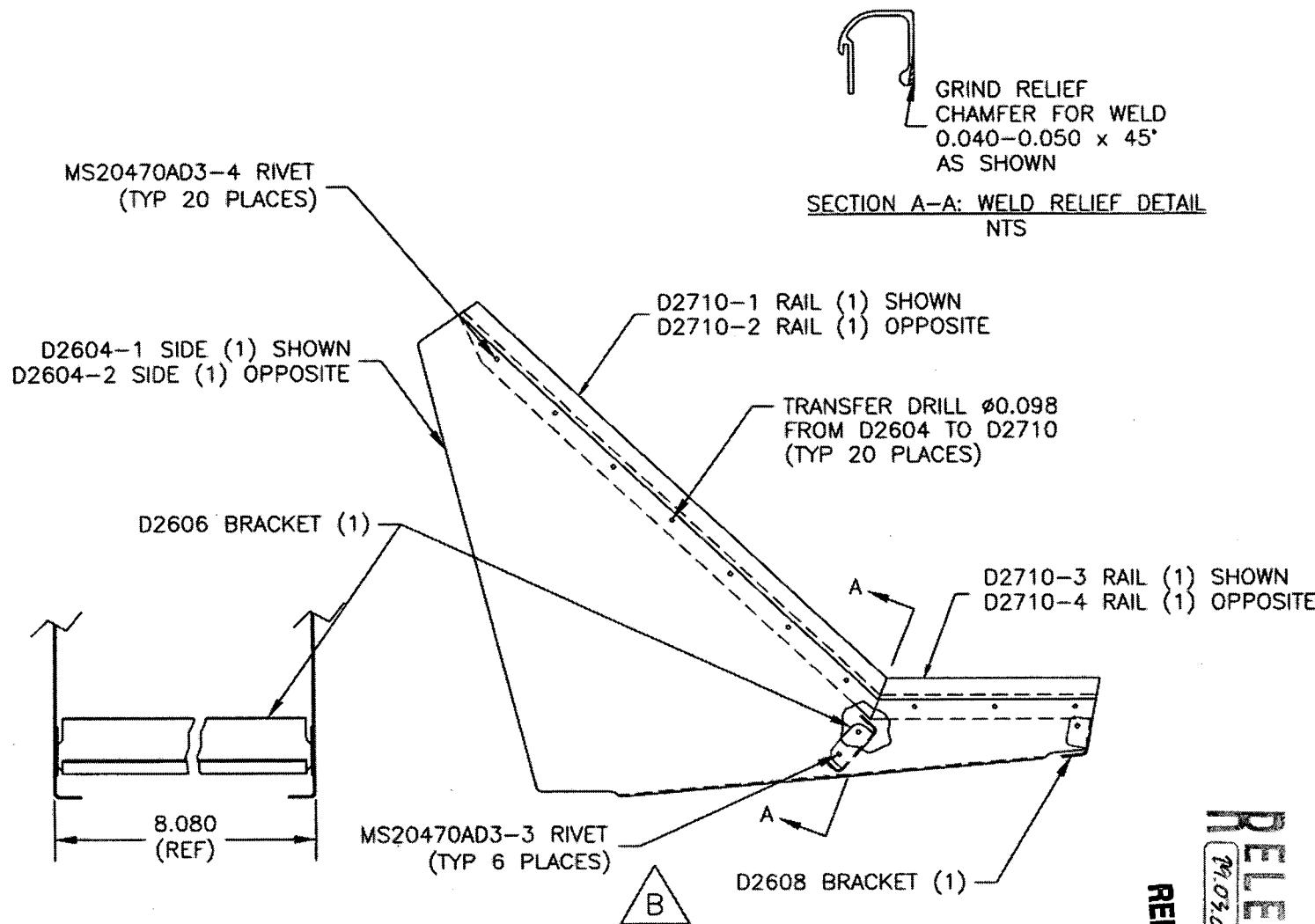
FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

RELEASED
M.0305 RE

DESIGN B.W.	DRAWN BY R.F.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JP</i>	APPROVED <i>KE</i>	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5 SCALE 1:4

DART



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
74.03.05 KE

REFERENCE ONLY

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CP	APPROVED RE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SHEET 5 OF 5 SCALE 1:4